

Work Order ID 140666

January 13, 2016 11:18:21 AM

140666

Need ASAP.

Please cut Jan 14-18 Page 1

Item ID: D4353-041

Accept

Revision ID:

Item Name: Bearpaw Assembly

Start Date: 1/13/2016 Start Qty: 14.00

14

Required Date: 1/19/2016 Req'd Qty: 14.00

14

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

5H

Date:

20160113

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4353

B

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.19

FLOW CNC Waterjet

Cut Blank as per D4353-1 File

15

DL 16-01-14

130

0.02

130

HAAS CNC VERTICAL MACHINING #1

HAAS 4

Memo

0.17

HAAS CNC vertical machine #4

1-Inspect material for defects or damage prior to machining.

2-Program batch number. Ensure that batch number reflects the W/O.

3-Machine as per Folio FB050 and Dwg.

FOLIO REV: 11

DWG REV: B

4-Deburr

165

SL 16-1-18

DAS

23

9-53

16-01-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube</td><td style="width:5%;">☐</td> <td style="width:15%;">Cross tube</td><td style="width:5%;">☐</td> <td style="width:15%;">Water Jet</td><td style="width:5%;">☐</td> <td style="width:15%;">Engineering</td><td style="width:5%;">☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>						Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐																																																																																																
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January 13, 2016 11:18:21 AM

Page 2

Stop ***NR2***

Packaging

DAS 5216-1-18
20
9-89 16-01-15

DAS
14
9-89
16/01/25

~~JAN 20 2016~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Page 3

Packaging

15 FF JAN 20 2016

15

15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 140666***140666***

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Item ID: D4353-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw Assembly
Start Date: 1/13/2016 Start Qty: 14.00 ***14*** Cust Item ID:
Required Date: 1/19/2016 Req'd Qty: 14.00 ***14*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.02							
Quality Control									

MCS JAN 20 2016

MCS JAN 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____ _____			
Misidentified	☐	Past Due	☐				

Picklist Print

January 13, 2016 11:18:25 AM

Page 1

Work Order ID: 140666

140666

Parent Item: D4353-041

D4353-041

Parent Item Name: Bearpaw Assembly

Start Date: 1/13/2016

Required Date: 1/19/2016

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP REV:A NEW ISSUE 11-04-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

sf

210.0730

89.6

MIJHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

DC 16/01/14

Location

Loc Qty

Loc Code

MAT018

210.073

m131661

1.473

m133248

23.4

m133642

185.2

Each

1.0000

96

14

D4353-3

Manufactured

No

D4353-3

Bearpaw Insert

DAS
30
9-89

JAN 20 2016

Location

Loc Qty

Loc Code

GA

1

125851

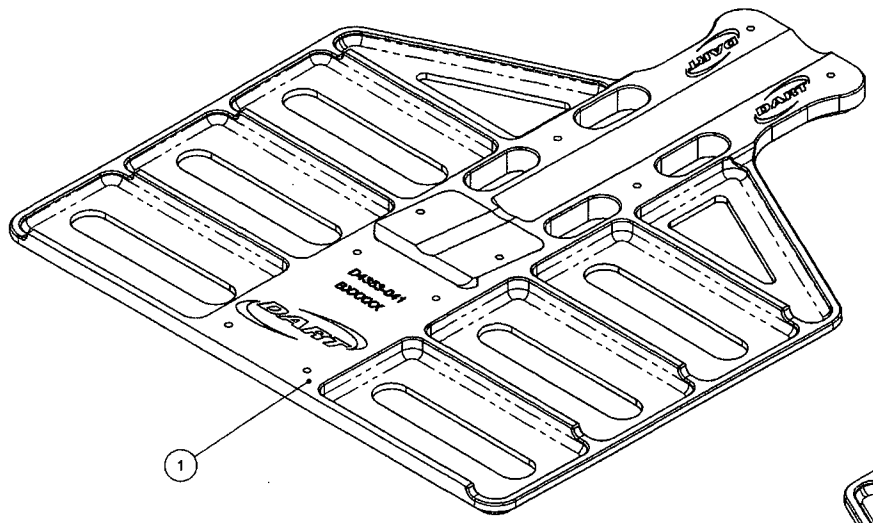
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B 140672

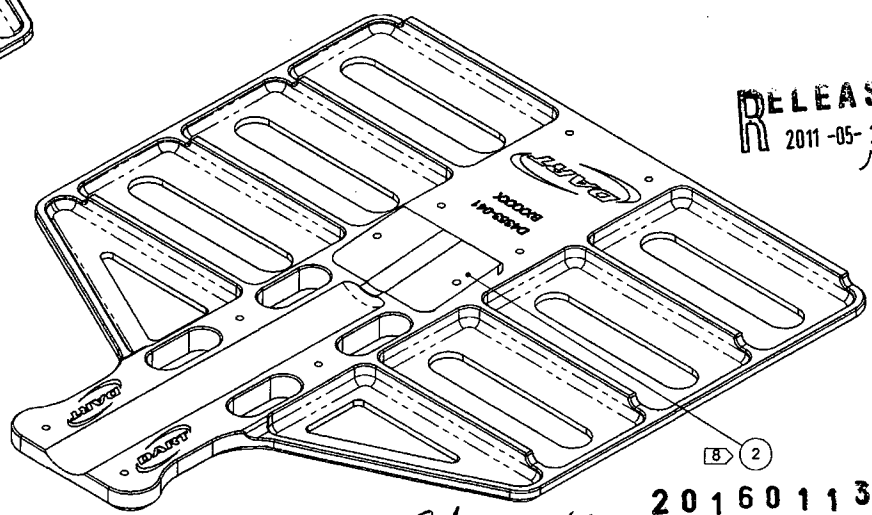
14

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4353-041	429 BEARPAW ASSEMBLY
1	1	D4353-1	429 BEARPAW
2	1	D4353-3	429 BEARPAW INSERT



D4353-041 429 BEARPAW ASSEMBLY



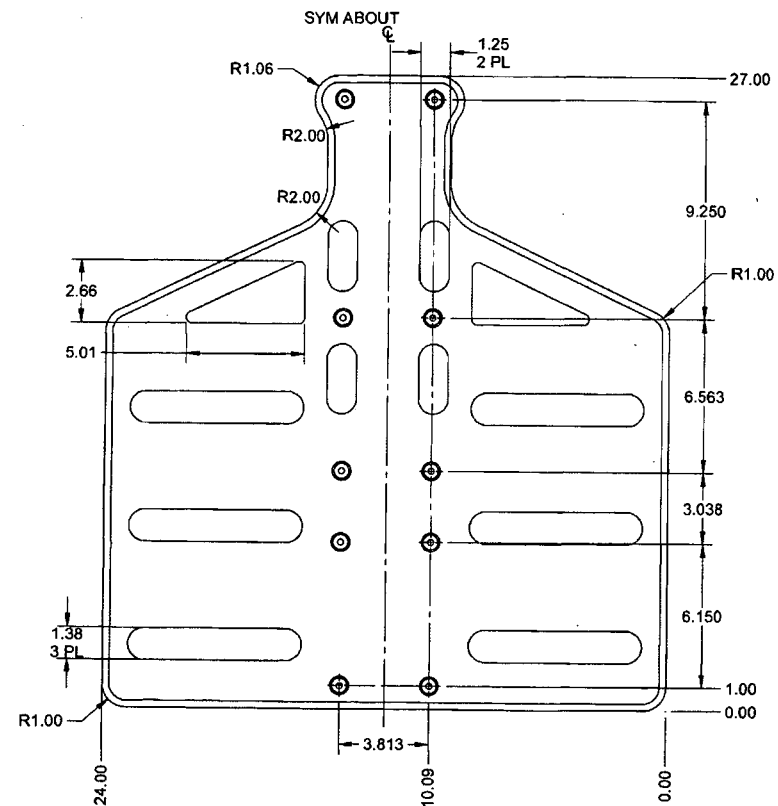
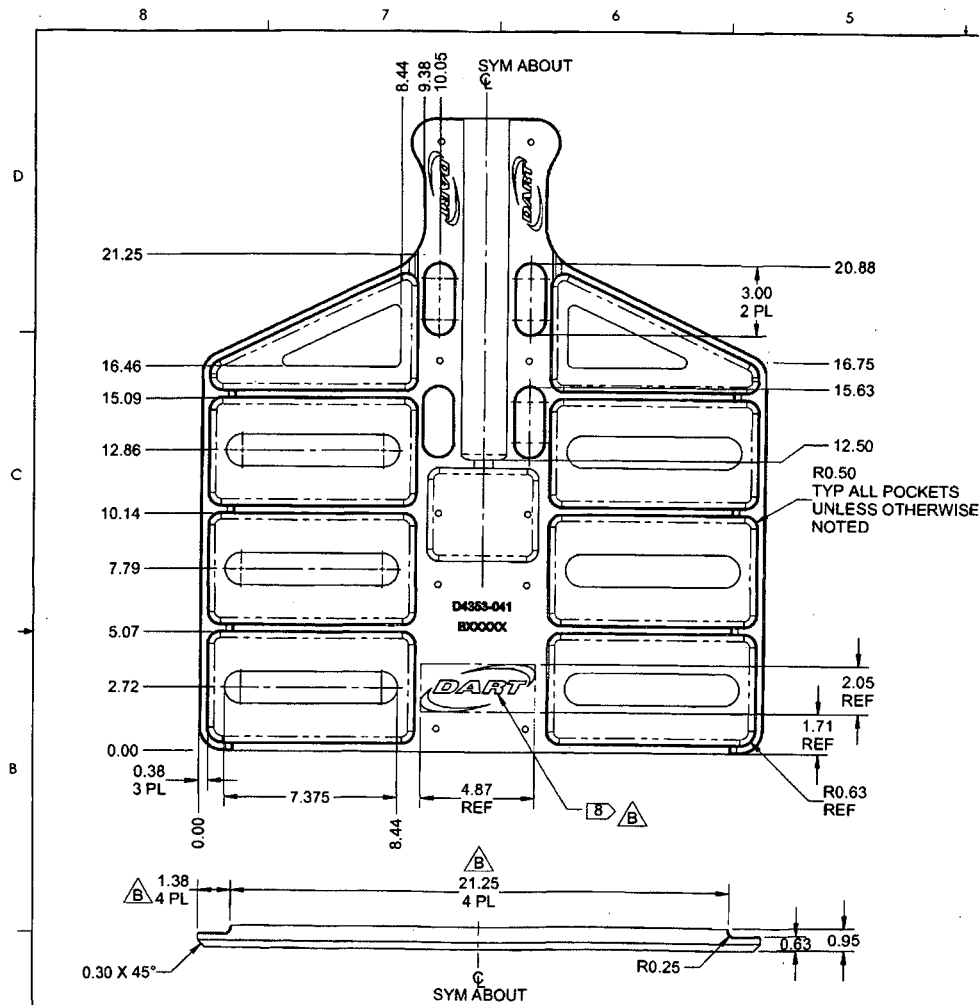
RELEASED
2011-05-24
AND

20160113

SA 140666

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 7.45 lbs
 - 8) PRESS FIT

B	SHT 1 WEIGHT CORRECTED WAS 8.24 lbs. SHTS 1-3 DART LOGOS UPDATED. SHT 2, ZONE B8, AFT POCKET REDUCED, RIB INCREASED IN HEIGHT. SHT 3 SECTS. B,C & D RIB INCREASED IN HEIGHT.		AJS	11.04.26
A	NEW ISSUE		AJS	11.03.24
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	140	DRAWING NO.	REV. B	
MFG. APPR.	140	D4353	SHEET 1 OF 4	
APPROVED	140	TITLE	SCALE	
DE APPR.	140	429 BEARPAW ASSEMBLY	NTS	
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



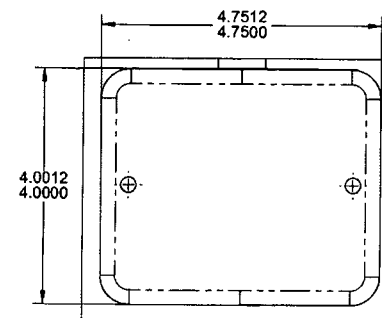
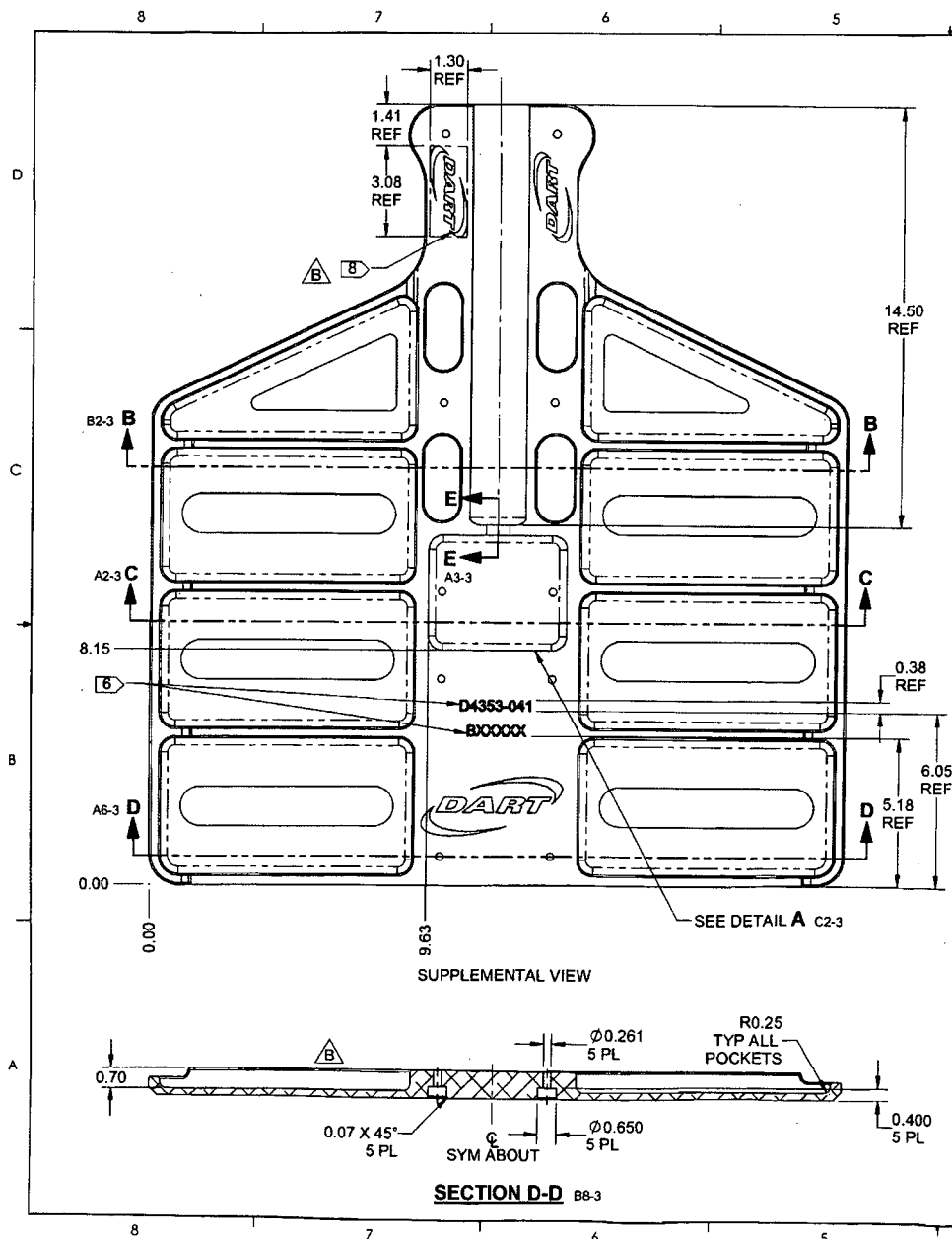
D4353-1 429 BEARPAW

RELEASED
2011-05-04
JN

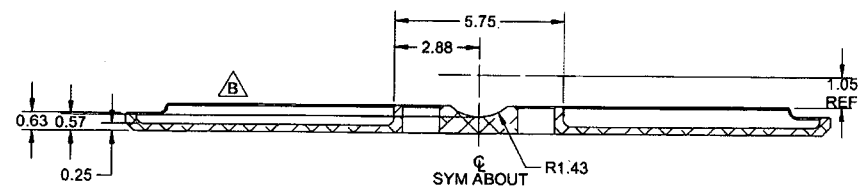
NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART ASSEMBLY P/N "D4353-041" AND B/N "BXXXXX" 0.005 - 0.010 DP AS SHOWN
- 7) WEIGHT: 7.07 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP.

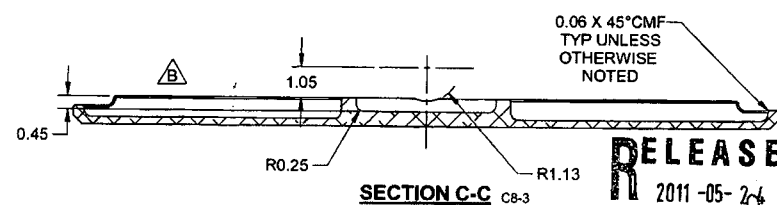
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4353	REV. B
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
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DETAIL A A5-3
(SCALE 2X)



SECTION B-B C6-3



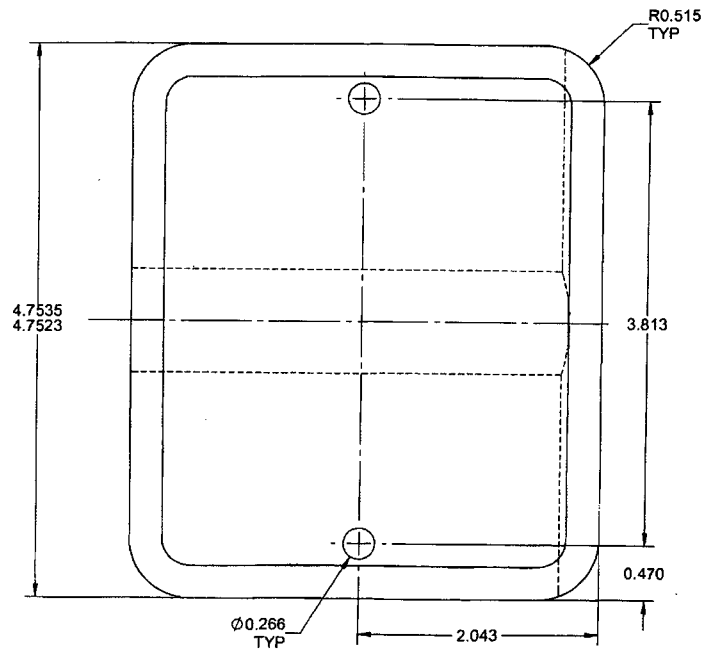
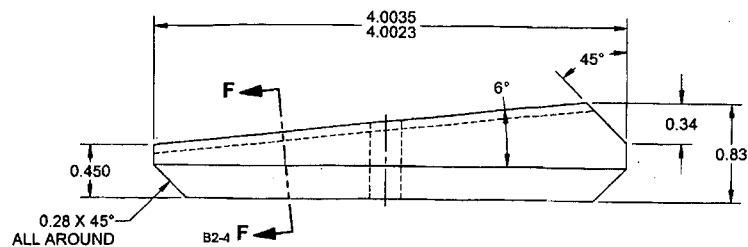
SECTION C-C C8-3



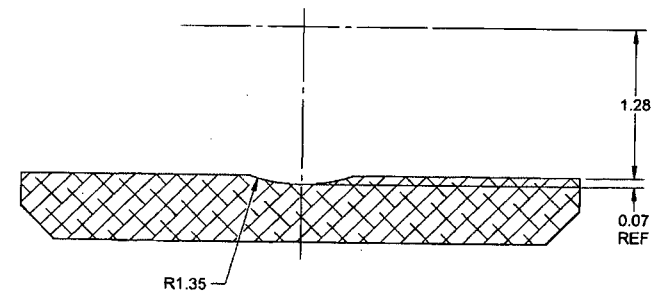
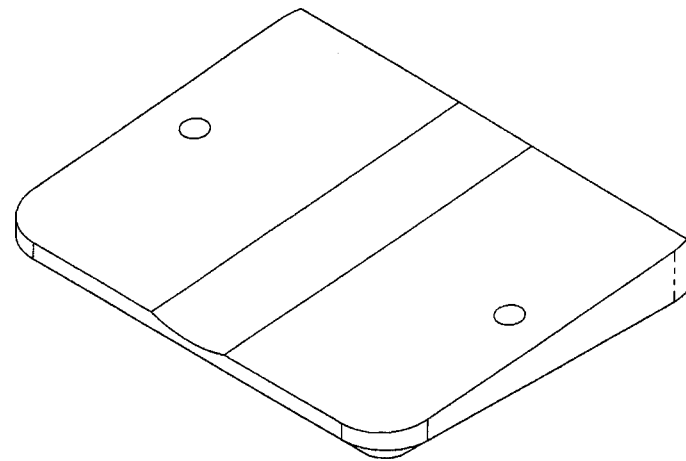
SECTION E-E C6-3
(SCALE 2X)

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MFG. APPR.	<i>[Signature]</i>		SHEET 3 OF 4
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RELEASED
2011-05-26



D4353-3 429 BEARPAW INSERT



SECTION F-F C7-4

RELEASED
2011-05-26

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
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DART AEROSPACE LTD		Work Order:	140660
Description: Bearpaw		Part Number:	D4353-1
Inspection Dwg: D4353 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	0.380	✓		SLIO	Vein
7.375	+/-0.010	7.379	✓		SLIO	Tape
12.50	+/-0.030	12.50	✓		"	
1.38	+/-0.030	1.380	✓		SLIO	
3.813	+/-0.010	3.814	✓		"	
24.00	+/-0.030	24.00	✓		SLIO	
10.09	+/-0.030	10.095	✓		"	
1.00	+/-0.030	0.990	✓		SLIO	
6.150	+/-0.010	6.150	✓		"	
3.038	+/-0.010	3.038	✓		"	
6.563	+/-0.010	6.563	✓		"	
9.250	+/-0.010	9.250	✓		SLIO	
27.00	+/-0.030	27.00	✓		"	
1.25	+/-0.030	1.254	✓		SLIO	
0.30 x 45°	+/-0.030	0.300	✓		"	
1.38	+/-0.030	1.381	✓		"	
0.63	+/-0.030	0.623	✓		"	
0.95	+/-0.030	0.945	✓		"	
R0.25	+/-0.030	0.250	✓		Rad gauge	
0.70	+/-0.030	0.699	✓		SLIO	
0.07 x 45°	+/-0.030	0.070	✓		"	
Ø0.650	+/-0.010	0.650	✓		"	
Ø0.261	+0.006/-0.001	0.260	✓		"	
0.400	+/-0.010	0.404	✓		"	
4.750	+0.012/-0.000	4.750	✓		"	
4.000	+0.012/-0.000	4.000	✓		"	
5.75	+/-0.030	5.750	✓		"	
0.63	+/-0.030	0.625	✓		"	
0.57	+/-0.030	0.570	✓		"	
0.25	+/-0.030	0.247	✓		"	
0.45	+/-0.030	0.450	✓		"	
0.06 x 45°	+/-0.030	0.07 x 45°	✓		"	
R0.25	+/-0.030	0.250	✓		Rad gauge	

Measured by:	20 9-80
Date:	16-01-15

Audited by:	14 9-83
Date:	16/01/20

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	P/O D4353-041	KJ